

Work Order ID 74472

Monday, October 03, 2011 9:25:24 AM

Page 1

Item ID: D2661-1

Accept

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00

Required Date: 10/28/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan: M.L.J.

Date: 11/10/03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2661

Rev D

100

0.00

B.A 11/11/24

9

0



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Fixturing Inspection last completed by ☐ 1-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually inspect as per attached Dimension

110

0.00

B.A 11/11/24

9

0



Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00

B.A 11/11/24

9

0



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QAWCRWO RevE

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Monday, October 03, 2011 9:25:24 AM



Page 2

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Jim 11.11.25

9 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

9 11.11.25

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

320°F

8:00

8:30

OK M 11/11/29

M118434

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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H:\FORMS\Quality Assurance\approved QANCRWO RevE

Work Order ID 74472

Page 3

Monday, October 03, 2011 9:25:24 AM

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				9		11-11-29	
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>435</u> Memo	0.00 0.00				11/11/30		82	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/11/30	

ME
11-11-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 9:25:40 AM

Page 1

Work Order ID: 74472



Parent Item: D2661-1



Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003

Manufactured

No

100

Each

73.0000

1

10



FK- 11/11/22

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT040

8

72226

8

MAT44

65

72226

5

73769

60

74650

X

9

9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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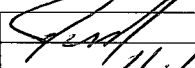
NOTE: Date & initial all entries


DART AEROSPACE LTD	Work Order: 74472
Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5 By	Date
A	0.100	0.140		.135	.134	.133	.134	.134	
B	0.100	0.140		.122	.123	.122	.121	.122	
C	1.250	1.270		1.1339	1.1337	1.1338	1.1330	1.1332	
D	0.615	0.685		.680	.680	.680	.680	.680	
E	0.240	0.260		.251	.251	.251	.252	.251	
F	1.437	1.467		1.323	1.324	1.325	1.324	1.325	
G	0.210	0.230		.225	.226	.227	.226	.225	
H	0.100	0.180		.135	.135	.135	.135	.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.5736	1.5741	1.5746	1.5731	1.5719	
K	0.235	0.240		.237	.236	.238	.236	.236	
L	0.100	0.120		.112	.111	.113	.111	.111	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.314	.314	.314	.314	.314	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.795	.795	.797	.796	.797	
W	0.540	0.560		.547	.549	.548	.547	.549	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.260	.260	.260	.260	.260	
Z	0.912	0.932		.923	.922	.923	.924	.921	
AA	0.490	0.510		.497	.495	.498	.500	.497	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	F.K.
Date:	11/11/23.

Audited by:	
Date:	11.11.23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74472
Description: 206 Saddle, Outboard, Left side		Part Number: D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:





Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				6	7	8	9		
A	0.100	0.140		0.133	0.133	0.133	0.132		
B	0.100	0.140		0.123	0.123	0.122	0.121		
C	1.250	1.270		1.1329	1.1331	1.1334	1.1333		
D	0.615	0.685		0.680	0.675	0.675	0.675		
E	0.240	0.260		0.252	0.252	0.252	0.252		
F	1.437	1.467		1.325	1.325	1.325	1.325		
G	0.210	0.230		0.225	0.222	0.222	0.222		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.5725	1.5716	1.5734	1.5731		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.113	0.111	0.111	0.111		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.970	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.796	0.797	0.797	0.797		
W	0.540	0.560		0.548	0.551	0.551	0.551		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.921	0.923	0.923	0.923		
AA	0.490	0.510		0.496	0.499	0.499	0.499		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

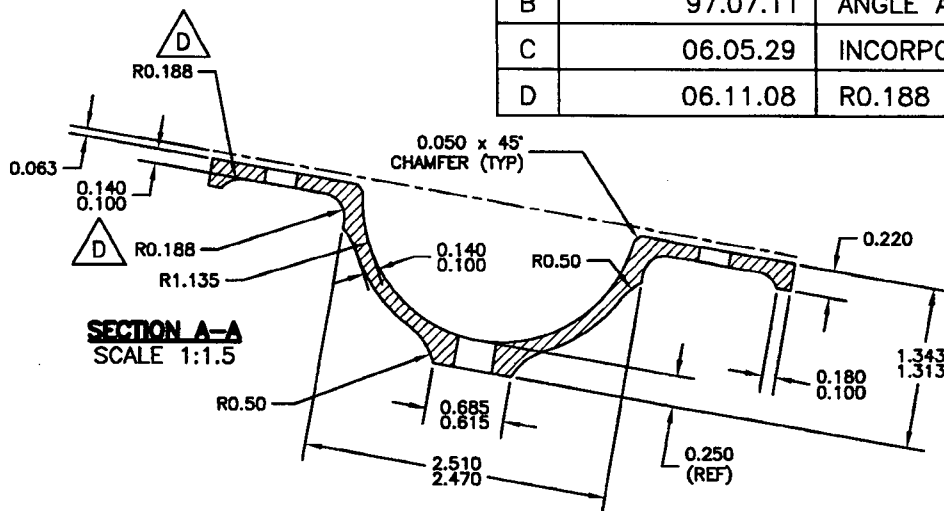
Measured by: F.K. / A.A.
Date: 11/11/23 / 11/11/24

Audited by: [Signature]
Date: 11.11.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
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E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN 		DRAWN BY 		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. REV. D D2661 SHEET 1 OF 1	
DATE 06.11.08		TITLE SADDLE OUTSIDE		SCALE 1:3	
A	97.03.25		NEW ISSUE		
B	97.07.11		ANGLE AND NOTES ADDED		
C	06.05.29		INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08		RO.188 WAS RO.30; ø0.316 WAS ø0.313		



RELEASED

07.02.12

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

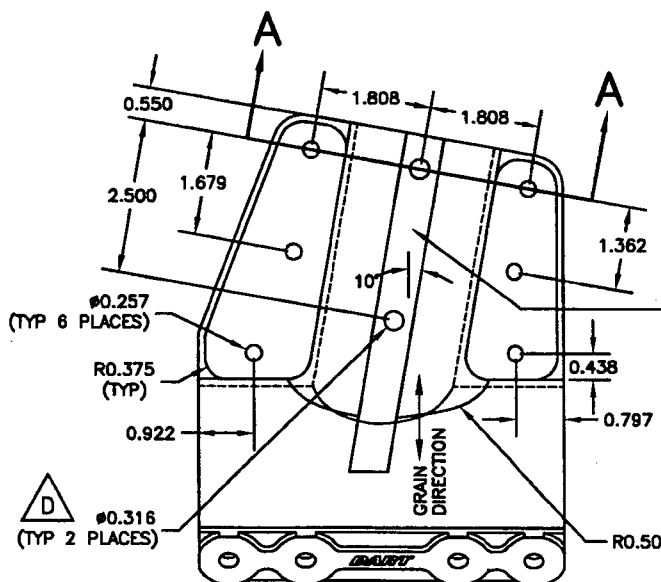
WORK ORDER

NO. 74472 H.L.J.

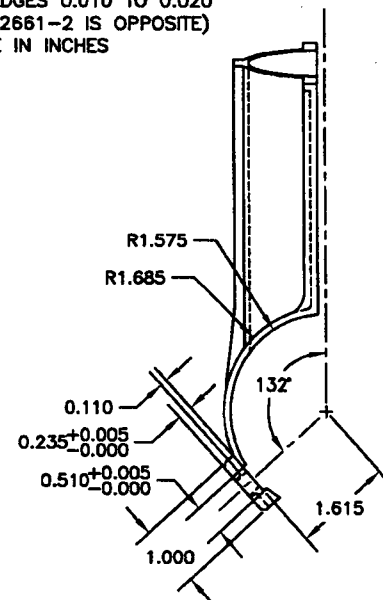
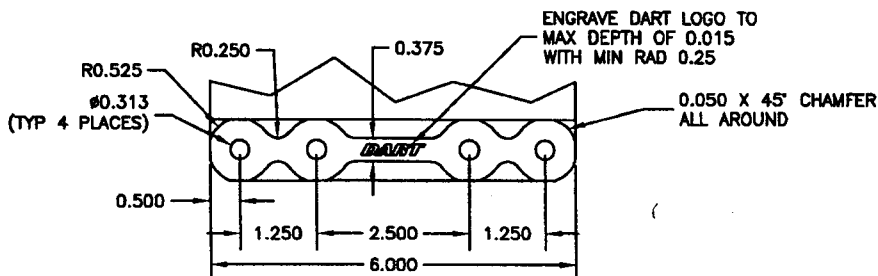
11/10/03

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

**D2661-1 SADDLE OUTSIDE**

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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